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Thursday, October 07, 2010 3:13:49 PM



Page 1

Item ID:

D206-642-541

Accept



Setup Start



Revision ID:

Item Name:,

Replacement Skidtube

Start Date:

10/7/2010

Start Qty: 1.00

Required Date: 10/15/2010 Req'd Qty: 1.00



Cust Item ID: Customer:

Reference:

Approvals:

QC:

Date: 10-10-07 Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Stop

Sequence ID/ Work Center ID

Operation **Description** Set Up/ **Run Hours** Tool ID

Tool # Plan Code

Reject Accept Qty Qty

Reject Number

Insp. Stamp

Draw Nbr

Revision Nbr

D3274 IIN-D206-642 D Rev M

100

DOCUMENT CONTROL

Memo

Date:

0.00

0.00

Document Control Photocopy bluefile & type labels per PPP D206-642-541

CHG003

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W/O:		 	W	ORK ORDER CHA	NGES					*
DATE	STEP	PROCEDURE CHANGE			Ву	Date	ation	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	Part No: PAR #: Fault Category: Resolution: Disposition:									
NCR:	,		WORK ORD	DER NON-CONFO	RMANCE	(NCR)			
DATE	STEP	Description of NC Section A	Corrective Action Section E Initial Action Description		Section B	Sign &	I	cation	Approval Chief Eng	Approval QC Inspector
•			Chief Eng	Chief Eng		Date				
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Thursday, October 07, 2010 3:13:49 PM

Page 2

Item ID:

D206-642-541

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/7/2010

QC:

Start Oty: 1.00

Required Date: 10/15/2010

Req'd Qty: 1.00



Date:_____

Cust Item ID: Customer:

Reference:

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- A	aa	ro	va	is:

Process Plan:

Date:

Tooling:

0.00

0.00

SPC (Y/N):

Date:

Date:

Run Start

Stop



Sequence ID/ **Work Center ID**

110



Skidtubes

Skidtubes

Operation Description

Skidtubes

Set Up/ **Run Hours**

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- Bend FWD end of tube using bend prog D3274 FWD and foilo 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and OSIQ04 AR Aluminum Rod Batch:

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

4- grind fwd cap weld on top surface only

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

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W/O: WORK ORDER CHANGES											
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No: _		PAR #:	Fault Category:	NCR: Yes No DQA:	_ Date:					
	Resolution:		Disposition:	QA: N/C Closed:	Date:					
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Work'Order ID 62767

Page 3

Thursday, October 07, 2010 3:13:49 PM

Item ID:

D206-642-541

Replacement Skidtube

Revision ID:

Item Name:

10/7/2010 **Start Date:**

QC:

Required Date: 10/15/2010 Req'd Qty: 1.00



Accept

Setup Start

Stop



Start Qty: 1.00 **Cust Item ID:**

Customer:

Reference:

Approvals:

Process Plan:

Date: _____ Date:_____

Tooling: SPC (Y/N):

Date:

Date:

Run

Start



Stop

Sequence ID/ **Work Center ID**

120

HandFinish

Hand Finishing

Operation Description

Chemical Conversion Coat per QSI005 4.1

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

130

QC

Quality Control

QC3- Inspect Part Finish

Memo

Memo

0.00

0.00

140

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

W/O:		WORK ORDER CHANGES							. ,	
DATE	STEP	PRO	CEDURE CHA	NGE	В	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: PAR #: Fault Category: NCR: Yes No DQA: Date:										
Resolution: Disposition: QA: N/C Closed: Date						Date:				
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Work Order ID 62767

Thursday, October 07, 2010 3:13:49 PM



Page 4

Item ID:

D206-642-541

Accept



Setup Start

Stop

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/7/2010

Start Qty: 1.00

Required Date: 10/15/2010

QC:

Reg'd Qty: 1.00



Cust Item ID:

Customer:

Tool ID

Reference:

Ap	prova	ls:

Process Plan:

Date: _____

Date:

Tooling:

SPC (Y/N):

Date: Date:

Start Run



Sequence ID/

Work Center ID

150

Skidtubes Skidtubes

Description

Operation

Set Up/ **Run Hours**

Tool # Plan

Accept Code Qty

Reject Qty

Reject Number Stamp

Insp.

Skidtubes

0.00

0.00

1-Open Ø0.313" and 0.375" crossbolt spacer holes using DT8743 as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

Finish: 10 10 79 Time: 5.300M (Adhere for 12 hours)

QC5- Inspect part completeness to step on W/O

160

QC

Quality Control

Memo

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W/O:		VVORK ORDER CHANGES								£
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NCR:		V	ORK OR	DER NON-CONFOR	MANCE	(NCR)				*
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Work Order ID 62767 Page 5 Thursday, October 07, 2010 3:13:49 PM D206-642-541 Item ID: Accept Setup Start **Revision ID:** Stop Replacement Skidtube **Item Name: Start Date:** 10/7/2010 Start Qty: 1.00 **Cust Item ID: Required Date:** 10/15/2010 Req'd Qty: 1.00 **Customer:** Reference: Run Start Process Plan: _____ Date: ____ Approvals: Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Work Center ID **Description Run Hours** Code Qty Number Stamp Qty 170 0.00 Skidtubes Skidtubes 0.00 Skidtubes 1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position. 2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297". Deburr 3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES 4- Countersink crossbolt spacer holes as per Dwg D3274 5- prepare for welding 180 QC5- Inspect part completeness to step on W/O 8 10/4/02 QC Memo

Quality Control

W/O:	WORK ORDER CHANGES							, , ,		
DATE	STEP	PROC	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	PAR #: Par #: NCF			ICR: Yes	_ Date: _			
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DATE	STEP	Description of NC	Corrective Action Section B				Verification			Approval
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Work Order ID 62767

Thursday, October 07, 2010 3:13:49 PM



Page 6

Item ID:

D206-642-541

Accept

Setup Start

Stop



Revision ID:

Replacement Skidtube Item Name:

Start Date:

10/7/2010

Start Qty: 1.00

Required Date: 10/15/2010

Req'd Qty: 1.00

Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date: _____

Date: Tooling:

SPC (Y/N):

Date:

Tool # Plan

Code

Date:

Run

Reject

Qty

Accept

Qty

Start

Reject

Number

Stop

1 V BE10/1



Insp.

Stamp

Sequence ID/ Work Center ID

190

Skidtubes

Skidtubes

Operation Description

Skidtubes

Set Up/ **Run Hours**

0.00

0.00

Memo

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use

aluminum rod

A/R□□Aluminum Rod□ M//

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

200

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

QC

Memo

0.00

W/O:			WC	RK ORDER CHANG	GES						
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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NCR:		,	WORK ORDI	ER NON-CONFORM	ANCE	(NCR	1)				
DATE	STEP	Description of NC Corrective Action Section B				verifica		cation	Approval		
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Work Order ID 62767

Thursday, October 07, 2010 3:13:49 PM



Page 7

Item ID:

D206-642-541

Accept



Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/7/2010

Start Qty: 1.00

Required Date: 10/15/2010

Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

App	rova	ls:
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Process Plan:

Date: Tooling:

Date:

Run

Stop

Start

Stop



Date: _____

SPC (Y/N):

Set Up/

Tool ID

Date:

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

Sequence ID/ **Work Center ID**

210

QC

Quality Control

Operation **Description**

QC10- Inspect visual per QSI004- ground welds

Run Hours

S idulos

220

HandFinish

Pressure Wash per QSI005 4.3

Memo

Memo

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

230

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M 115291

START TIME:

OVEN TEMPERATURE FINISH TIME:

1 \$10-11-3.

W/O:	O: WORK ORDER CHANG				iES					
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Resolution: Disposition:			ion:	_ QA: N/C C	losed:		Date: _			
NCR:		V	WORK OR	DER NON-CONFORMA	NCE (NC	₹)			`.	
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Work Order ID 62767

Thursday, October 07, 2010 3:13:49 PM



Page 8

Item ID:

D206-642-541

Accept



Setup Start

Stop

Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/7/2010

Start Qty: 1.00

Req'd Oty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: _____ Tooling:

Date: ____

Date:

Run



Required Date: 10/15/2010

QC:

Date: _____

SPC (Y/N):

Tool ID

Tool # Plan

Code

Accept Reject Qty Oty

Reject Number

Insp. Stamp

Sequence ID/ Work Center ID

240

QC

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours**

0.00

0.00

10/4/01

250



Hand Finishing

HandFinishing

Memo

Memo

lolulou

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. A/RON/AOLPS-30 //(109956

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a \sim A/R \square Sikaflex-291 \square \sim ((S1) \rightarrow \square

Sikaflex expire date:

11101

260



Quality Control

QC5- Inspect part completeness to step on W/O

Inspect Nut Plate & Inserts

W/O:			WO	RK ORDER CHANGE	ES				, ,
DATE	STEP	PRO	OCEDURE CHAN	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	gory:	NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Disposition	n:	QA: N/C C	osed:		Date: _	
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NCF	R)			
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Thursday, October 07, 2010 3:13:49 PM



Page 9

Item ID:

D206-642-541

Accept

Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/7/2010

Start Qty: 1.00

Required Date: 10/15/2010 Req'd Oty: 1.00



Cust Item ID:

Customer:

Tool ID

Reference:

A	D	DI	10	V	a	ls	:

Process Plan:

QC:

HAND FINISHING RESOURCE #1

Memo

Date: Date:

1-Install wearpads & gaskets as per Dwg D3274.

Tooling: SPC (Y/N):

Date: Date:

Tool # Plan

Code

Start Run

Reject

Otv

Stop

Number Stamp

Insp.

Sequence ID/ **Work Center ID**

270



HandFinish

Hand Finishing

Operation Description

Set Up/ **Run Hours**

0.00

Accept

Qty

Reject

2-Install ring as per Dwg D3274

A/R DSikaflex-291 D LILS/154

Sikaflex expire date:

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3 Batch: 10/14 LPS-3

5-Install Aft Cap and seal with Sikaflex. Cleap excess adhesive.

A/R□□Sikaflex-291 □ ____/// 1 5 ∫ (1□1)

11101

Sikaflex expire date:

QC5- Inspect part completeness to step on W/O

0 11/01

280



Sioluloy

Quality Control

Memo

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W/O:	ļ	The second secon	W	ORK ORDER CHANGES	y .				
DATE STE		PRO	OCEDURE CHA	NGE	Ву	Date	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC Section A	Initial	Corrective Action Section B Action Description	Sign 8	1 36011		Approval Chief Eng	Approval QC Inspector
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Work Order ID 62767

Thursday, October 07, 2010 3:13:49 PM



Page 10

Item ID:

D206-642-541

Accept



Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/7/2010

Start Qty: 1.00

Required Date: 10/15/2010 Req'd Qty: 1.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan: _____

Date:

Date:_____

Tooling:

Date: ____

Tool ID

Run

Start

Stop



SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID

290

Packaging Packaging

Operation Description

Identify as per dwg & Stock Location:

Set Up/ **Run Hours**

0.00

Tool # Plan

Accept Qty Code

Reject

Reject Insp. Number Stamp

300

QC21- Final Inspection - Work Order Release

0.00



Quality Control

Memo

0.00

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W/O:			WO	RK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cateo	jory:	NCR: Yes	No DQ	A:	Date:	
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Picklist Print

Thursday, October 07, 2010 3:13:53 PM

Work Order ID: 62767

D206-642-541

Parent Item Name:

Replacement Skidtube



Start Date: 10/7/2010

Start Qty: 1.00

Required Date: 10/15/2010

Page 1

Required Oty: 1.00

Comments:

Parent Item:

IPP Rev:B□05.09.23□Revised per D206-642 Rev. J□KJ/JLM

IPP Rev:C 07-02-23 IPP Rev:D 07-12-06

Added SS Wearplates & Gaskets JLM replace NAS1515H3L to D3672-1 DD

IPP Rev:E 08-04-17

as per PAR 08-015 DD verified by:EC

IPP Rev:F 08-06-02 IPP Rev:G

add comment DD verified by:EC 08-10-09 revise details DD verified byEC

No

No

No

Com	ponent	Item	ID/	
Item	Name			

кері	acemen
Item	ID

Mfg/	
Purch	

Manufactured

Manufactured

Manufactured

Bin	Primary
Item	Location

Last Location

Route Seq ID

110

110

150

Unit of

Each

Measure Hand

Qty on

73.0000

Qty per Kit

Total **Qty**

Qty **Issued**



Status

D2600-1-190

Extrusion Round 3" 206

Location



Loc Qty 73 25

48

Each

Loc Code

141.0000

D3285-1

Cap

LG

52511 52647 Loc Qty 141 74 67 Loc Code

BE 10/10/14

D3282-041

Float Web (206L/407)

Location

LG

Loc Qty

Loc Code

2.0000

59886

2

Each

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W/O:	Ĩ		N	ORK ORDER CHA	ANGES					
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Picklist Print

Thursday, October 07, 2010 3:13:53 PM

Work Order ID: 62767 Parent Item: D206-642-541 Parent Item Name: Replacement Skidtube Start Date: 10/7/2010 Required Date: 10/15/2010 Start Qty: 1.00 Required Oty: 1.00 D2649 Manufactured 190 Each 65.0000 Cross Bolt Spacer Location Loc Oty Loc Code LG 65 58545 60652 59 61496 D3275-1 Manufactured No 190 Each 216.0000 12 Crossbolt Spacer Location Loc Oty Loc Code LG 216 8 61646" 102 62399 106 CR3212-4-03 Purchased No 250 Each 1,888.000 Cherry Rivet Location Loc Qty Loc Code ST311 1888 111359 5 112314 2 114436 448 114450 71 114859 1362 D3415-041 Manufactured No 250 Each 52.0000 10/11/04 Nut Plate Loc Oty Location Loc Code ST056 52 33842 52 Thursday, October 07, 2010 3:13:53 PM **Shop Packet Print** Page 2

W/O:			W	ORK ORDER CHAN	GES					
DATE	STEP	PRO	CEDURE CH	ANGE	·	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:		1	WORK OR	DER NON-CONFORM	JANCE	(NCR)			•
DATE	STEP	Description of NC Section A	Initial	Action Description	Section B otion Sign & Date		Verification Section C		Approval Chief Eng	Approval QC Inspector
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Thursday, October 07, 2010 3:13:53 PM

Work Order ID: 62767								· · · · · · · · · · · · · · · · · · ·	
Parent Item: D206-642-541						11			
Parent Item Name: Replacement Skidtu	be			**************************************			Start Date: 1 Start Qty: 1		Required Date: 10/15/2010 Required Qty: 1.00
CCR264SS3-3 Cherry Rivet	Purchased	No			250	Each	446.0000 2	2 JU	10/1/04
			Location		<u>L</u>	oc Oty	Loc Code		7
			ST311			446			
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ALS4-1032-130	D 1 1	NI-		113973	250	398	1 1 4 7 0 0 0 7 0	X	
	1 ai viiaova	No			250	Each	1,147.000 78	78	
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				114723		1098	1115911	' . 	-
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				110511		10			
			ST381			39		 	<u></u>
D3536-15	34 6 . 1	NI-		114654	270	39	21,000	<u>-</u>	
	Manufactured	No			270	Each	21.0000 1	1 1. N	
Gasket								_ YY	10/11/01
			Location		<u>L</u>	oc Oty	Loc Code		
			FP			9			
				56055		1			
				60875		8			_
			FP11	50229		12		<u> </u>	<u></u>
				59238 62459		1 11			_
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W/O:			W	ORK ORDER CHANG	ES				. v
DATE	STEP	PRO	OCEDURE CHA	EDURE CHANGE			te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	egory:	_ NCR: Ye	s No	DQA:	_ Date: _	
Resolution:				_ Disposition: QA: N/C Closed: Date					
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE (N	CR)			
DATE	OTED	Description of NC Corrective Action			tion B	v	/erification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n &	Section C	Chief Eng	QC Inspector
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Thursday, October 07, 2010 3:13:53 PM

Work Order ID: 62767 Parent Item: D206-642-541 Parent Item Name: Replacement Skidtube **Required Date: 10/15/2010 Start Date: 10/7/2010** Start Qty: 1.00 Required Qty: 1.00 D3536-23 Manufactured 270 Each 8.0000 Gasket Location Loc Qty Loc Code FP011 B63341 61237 8 D3536-35 Manufactured No 270 Each 23.0000 Gasket Location Loc Qty Loc Code FP012 23 58683 1 61692 10 62462 12 D3536-39 Manufactured 270 No Each 12.0000 Gasket Location Loc Qty Loc Code FP12 12 58215 1 58571 11 D3535-15 Manufactured No 270 Each 12.0000 Wearshoe Loc Oty Location Loc Code FP18 12 61241 6 62241

W/O:		44	W	ORK ORDER CHANG	ES					4
DATE	STEP	PRO	PROCEDURE CHANGE						Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	egory:	_ NCF	: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition	on:	_ QA:	N/C CIG	sed:		Date: _	· .
NCR:		1	WORK ORD	ER NON-CONFORM	ANCE	(NCR)			
DATE	OTED	Description of NC		Corrective Action Section B			_ Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sect	ion C	Chief Eng	QC Inspector
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Picklist Print

Thursday, October 07, 2010 3:13:53 PM

Page 5

Work Order ID: 62767 D206-642-541 Parent Item: Parent Item Name: Replacement Skidtube **Start Date:** 10/7/2010 **Required Date: 10/15/2010** Start Qty: 1.00 Required Qty: 1.00 D3535-35 Manufactured No 270 Each 8.0000 Wearshoe Location Loc Qty Loc Code FP018 60865 D3535-39 Manufactured 270 Each 17.0000 Wearshoe Location Loc Qty Loc Code FP18 17 58214 1 60233 16 D3535-23 Manufactured No 270 Each 19.0000 Wearshoe Location Loc Qty Loc Code FP 7 61830 7 FP021 20 60231 11 D3537-3 Manufactured No 270 Each 6.0000 Wearpad Location Loc Qty Loc Code FP17 B61674 60866

Dart Ae	rospace I	Ltd								
W/O:			W	ORK ORDER CH	ANGES					,
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:			-	DER NON-CONFO						
		Description of NC	Description of NC				Verific	cation	Approval	Approval
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Thursday, October 07, 2010 3:13:53 PM

Work Order ID: 62767

D206-642-541

Parent Item Name:

Parent Item:

Replacement Skidtube



Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Oty: 1.00

D3537-1

Wearpad

Manufactured

270 Each

14.0000

Locatio	<u>n</u>	Loc	c Oty	Loc Code		
FP		•	1	136266	۱ ر	<u> </u>
	55465		1	(•	
FP017			6			
	61986		6			
FP17	,		7			
	57713		3			
	60491		3			
	61640		1			
		270	Each	29.0000	80	80

AN960C10L

NAS1149C0332

Purchased

No

No

1115832



washer

AN960C416

NAS1149C0463

Purchased

Location

ST245

270

107534

Loc Qty 29 29 Each

100.0000

Loc Code

11115358



July year 10/11/04

|--|

washer

Location Loc Qty ST346 100 100993 100 Loc Code

		· —								
W/O:			W	ORK ORDER CHANGE	ES					2
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	R	esolution:	Disposition: QA			VC Clo	sed:	y	Date:	
NCR:		•	WORK ORI	DER NON-CONFORMA	NCE	(NCR)				
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description		Sign &	Verific Secti	cation	Approval Chief Eng	Approval QC Inspector
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Thursday, October 07, 2010 3:13:53 PM

Work Order ID: 62767 Parent Item: D206-642-541 Parent Item Name: Replacement Skidtube **Start Date:** 10/7/2010 **Required Date: 10/15/2010** Start Qty: 1.00 Required Qty: 1.00 D3672-1 Manufactured No 270 Each 855.0000 Phenolic Washer Location Loc Oty Loc Code ST077 855 42329 150 52505 705 AN3C4A Purchased No 270 Each 1,650.000 80 **BOLT** Location Loc Oty Loc Code ST245 20 110139 20 ST303 42 115438 42 ST350 1588 114108 14 114416 12 114523 2 115300 560 1000 115589 AN4C5A Purchased No 270 Each 489.0000 **BOLT** Location Loc Qty Loc Code ST346 489 110552 112243 485

W/O:		WORK ORDER CHANGES											
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	Ŕ	esolution:	Disposit	ion:	_ QA: N/C Closed: Date								
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (N	CR)							
DATE	STEP	Description of NC		Corrective Action Section			Verific	ation	Approval	Approval			
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & late	Secti		Chief Eng	QC Inspector			
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Picklist Print

Thursday, October 07, 2010 3:13:53 PM

Page 8

Work Order ID: 62767

Parent Item:

D206-642-541

Parent Item Name: Replacement Skidtube



61322

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2646

Aft Cap

Manufactured

Manufactured

270

Each 44.0000

Location	Loc Qty	
FP-4	39	
<u>57332</u>	39	
fp5	1	
61752	1	
FP6	4	
52663	4	
-	270 Each	

31.0000

Loc Code

D3413-1



Ring

Location	Loc Oty	Loc Code
ST473	31	
51586	1	
53446	15	

15

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
								Prod Mgr	•				
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DATE	CTED	Description of NC		Corrective Action Section B		Verifi	Verification	Approval	Approval				
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		CP		PORT HADLOCK, WA
	CHECK	(ED	APPROVED #	DRAWING NO. REV. D
		#	-#	D3274 SHEET 1 OF 4
	DATE		· · · · · · · · · · · · · · · · · · ·	TITLE SCALE
	06.1	2.19		SKIDTUBE ASSEMBLY NTS
	Α		04.03.15	NEW ISSUE
	В		04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76
	C		05.03.16	ADD -043; NEW INSERTS
	D		06.12.19	NEW INSERTS, SS WEARSHOE + GASKET



Qty	Qty	Dort Number	Perceintion	
-041	-043	Part Number	Description OVERTUPE A COUNTY OF THE PROPERTY	
<u> </u>		D3274-041	SKIDTUBE ASSEMBLY	
	X	D3274-043	SKIDTUBE ASSEMBLY	
1	1	D2600-1-240	EXTRUSION	
1	1	D2646	AFT CAP	
12	12	D2649	CROSS BOLT SPACER	
12	37	D3275-1	CROSS BOLT SPACER	
1	1	D3282-041	FLOAT WEB	
1	1	D3285-1	CAP SHOP COLY	
1	1	D3413-1	RING RETURNS	
1	1	D3415-041	NUT PLATE PROPERTY G	
1	1	D3535-15	WEARSHOE LINCONGE	
1	1	D3535-23	WEARSHOE UNCONTROLLE) C	OPY
1	1	D3535-35	WEARSHOE SUBJECT TO AME: THE	ENT
1	1	D3535-39	WEARSHOE WITHOUT NOT	
1	1	D3536-15	GASKET WORK ON R	
1	1	D3536-23	I MADREI NO COI-	
1	1	D3536-35	GASKET Color	フ
1	1	D3536-39	GASKET	. 1
9	9	D3537-1	WEARPAD IL/10/10	I-C
1	1	D3537-3	WEARPAD	
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)	
80	80	AN3C4A	BOLT	
1	1	AN4C5A	BOLT	
1	1	AN960C416	WASHER	
80	80	AN960C10L	WASHER	
2	2	CCR264SS3-3	RIVET	
2	2	CR3212-4-03	RIVET	
2	2	NAS1515H3L	WASHER	

GENERAL NOTES:

- 1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2. DAMAGE TOLERANCE ON FWD BEND:

THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

- 3. ALL HOLES DRILLED ON CENTERLINES.
- 4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- 5. WELDING TO BE DONE PER DART QSI 004.
- 6. FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
- 8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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W/O:			\MO	RK ORDER CHANG					
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
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SEE DETAIL A 30.82 DEO ATTACHED ø0.375 -SEE DETAIL A — 22.51 — 13.01 30.000 12.000 30.000 4.01 --6.000 15.000 15.000 - 2.500 ø0.313 2.500 **-** 17.26 (TYP, 12 PLACES PER SIDE) D3282-041 FLOAT WEB 35.07 15.46 45.33 TO WEB 82.250 94.57 42.14 -– 190 (REF) -12239 D3274-041 DRILLING/ASSEMBLY DETAIL 2.5" ALONG BEND CENTER ø0.640 (REF) - 3.0 ■ 6.24 32.7 7.00 - 111.1 (TANGENT-TANGENT DIST.) 4.5 - 170.9 (REF) D3274-041 BEND/DRILLING DETAIL -DETAIL E D3285-1 CAP SEE DETAIL F FINISH PER DETAIL B -D3536-39 D3536-35-GASKET FINISH PER DETAIL C (TYP, 12 PLACES) GASKET (TYP, 12 PLACES) 32.7 -D3536-23 D3536~15 GASKET GASKET D3537-1 D3535-35 WEARSHOE WEARPAD D3537-1 D3537-1 WEARPAD WEARPAD D3535~39 WEARSHOE D3537-3 D3535-23 WEARSHOE WEARPAD D3537-1 D3274-041 SKIDTUBE ASSEMBLY WEARPAD (SEE DETAIL D FOR WEARSHOE INSTALLATION) D3535-15 WEARSHOE RELEASED DART AEROSPACE USA, INC. DART 07.02.12 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL.
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM D3274 SHEET 2 OF DATE SCALE 06.12.19 SKIDTUBE ASSEMBLY DART AEROSPACE USA, INC. 1:15

Dart Ae	rospace Lt	d										
W/O:			WC	RK ORDER CHANGE	S	. •						
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
			197-1884									
Part No: PAR #		PAR #:	Fault Cate	NCR: Yes	No DQ	A:	Date:					
	Resc	olution:	Disposition:		QA: N/C Closed:							
NCR:			WORK ORDI	ER NON-CONFORMAT	NCE (NCR)						
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval			
	O.E.	Section A	Initial Chief Eng			Section C		Chief Eng	QC Inspector			
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DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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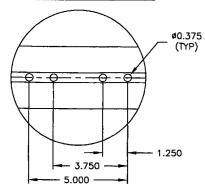
30.82 -SEE DETAIL A 1.500 (TYP) -SEE DETAIL A Ø0.375 **----** 22.51 — DEO ATTACHED - 30.000 13.01 15.000 ----3.000 PITCH 4.01 3.000 PITCH---1.500 (TYP) 3.000 PITCH-1.500 -2.500 · Ø0.313 (TYP) **---** 17.26 **--**-(TYP. 37 PLACES PER SIDE) D3282-041 - 35.07 15.46 FLOAT WEB TO WEB 82.250 - 91.57 42.14 190 (REF) D3274-043 DRILLING/ASSEMBLY DETAIL 2.5" ALONG BEND CENTER Ø0.640 (REF) - 3.0 32.7 - 111.1 (TANGENT-TANGENT DIST.) — 170.9 (REF) – D3274-043 BEND/DRILLING DETAIL D3285-1 CAP SEE DETAIL F -DETAIL E FINISH PER DETAIL B 03536-35 FINISH PER DETAIL C D3536-39-(TYP, 12 PLACES) GASKET GASKET (TYP, 37 PLACES) 32.7 -D3536-23 GASKET D3536-15 GASKET D3537-1 D3535-35 WEARPAD D3537-1 D3537-1 WEARSHOE WEARPAD WEARPAD D3537-3 D3535-39 D3535-23 WEARSHOE WEARSHOE WEARPAD D3537-1 D3274-043 SKIDTUBE ASSEMBLY WEARPAD (SEE DETAIL D FOR WEARSHOE INSTALLATION) D3535-15 RELEASED WEARSHOE DART AEROSPACE USA, INC. PH DART THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. REV. D D3274 SHEET 3 OF 06.12.19 SKIDTUBE ASSEMBLY

Dart Aerospace	e Ltd
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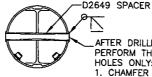
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DATE	STEP	Description of NC			on B	Verification			Approval	Approval	
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all 62767.

DETAIL A: DRILL DETAIL



DETAIL B FOR Ø0.375 HOLES ONLY



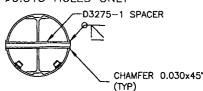
AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR \$0.375 HOLES ONLY:

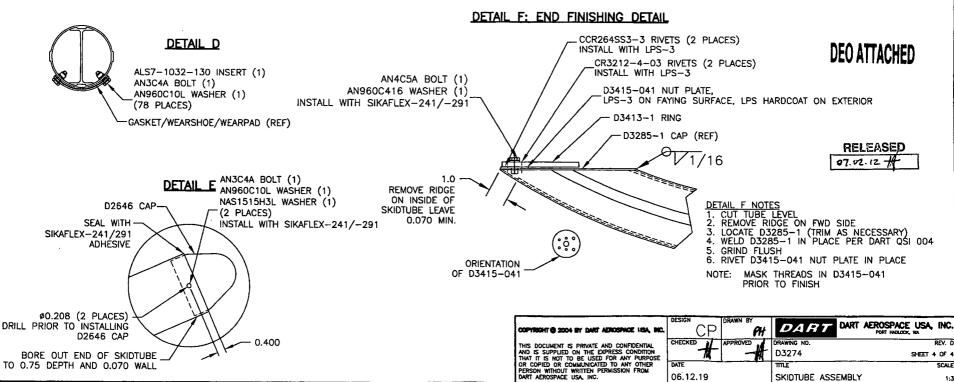
- 1. CHAMFER HOLE 0.030x45°
- 2. INSERT D2649 SPACER
- 3. WELD INTO PLACE AND GRIND FLUSH
- 4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL_CFOR Ø0.313 HOLES ONLY

06.12.19

SKIDTUBE ASSEMBLY





W/O:			WORK ORDER CHANGES								
DATE	STEP	PR	OCEDURE CHAP	IGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No			PAR #: Fault Category:		_ NCR: Yes 1	Date: _					
	Res	solution:	Disposition	n:	_ QA: N/C Clo	sed:	Date: _				
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DATE	STEP	Description of NC		Corrective Action Section		Verification		Approval			
	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector				
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DRAWING NO.	TITLE	, REV. D DART	AEROSPACE USA, II	NC D.E.O. NO.	SHEET NO.	SCALE
D3274	SKIDTUBE ASSEMBLY	EN	GINEERING ORDER	D3274-D-1	SHEET 1 OF 1	NTS
DRAWN (CHECKED	MFG.	. APPR.	APPROVED M	DE APPR.	
DATE 09.	06.17 DATE 09.06	. 2.3 DATE	09/06/23	DATE 09/06/23	DATE 09 06 23	

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

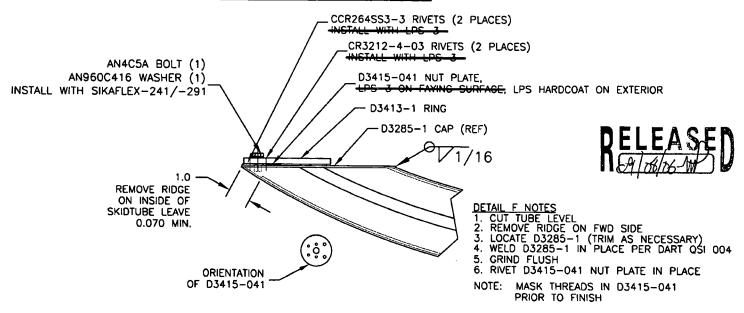
AMEND NOTE 8: "SPRAY INSIDE OF TUBE WITH A COAT-OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS:

COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

w/o 62747

DETAIL F: END FINISHING DETAIL



W/O:		WORK ORDER CH	WORK ORDER CHANGES							
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No) :	PAR #:Fault Category:	NCR: Yes	No DQ	A:	Date:				

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification	Approval	Approval	
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				**					

NO. 241

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Barclay Elliott		
Job number: 62280 8		
Part number: D206 642 · 541		
Description: 206 skid		
Welding Process: Tig[Mig[]	٠	*,
Base materiel: Aluminum	· · · · · · · · · · · · · · · · · · ·	
Current: AC DC[]		

TEST REQUIREMENTS AND RESULTS

Visual: Penetration:	pass[i] fail[] pass[] fail[]
UNACCEPTABLE	
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[]
Qualifier De la Melder Roslay Elloct	Date of Test Coupon 10.09.30 Date of Test Coupon 10.09.30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld.